Date:

Monday, 08/09/2008 2:51:00 PM

User:

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 41897

: 10313

P.O. Number

This Issue

: 08/09/2008

: NC

: // First Issue

Prsht Rev.

Previous Run

: 41735

: SMALL /MED FAB Type

Part Number

Drawing Name

: D26483 : D2648 REV D

Drawing Number Project Number

: N/A

: WEARPAD

Drawing Revision

Material

Due Date

: 20/09/2008

Qty:

40 Um:

Each

Written By

Checked & Approved By Comment

: Est: E 02.09.18

S.O. No. :

Re-format; Incorporated D2648-1 KJ/RF

Est Rev:F Now on Waterjet 06-08-14 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M1010S16GA

1010/1025 sheet 16GA



Comment: Qty.:

0.0788 sf(s)/Unit

3.1500 sf(s)Total:

1010/1025/A21/6aA SHEET

(M1010S16GA)

Batch: 16576(c

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2648

***********CUT WITH FILE D2648-1****************

Dwg Rev:

B 8-9-14

Prog Rev:__

2-Deburr if necessary

QC2



B 8-9-11



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

3.0

QC8

SECOND CHECK

Comment: SECOND CHECK



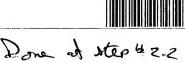
counter

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr of necessary



Dari Aei	rospace	e Lia											
W/O:		WORK ORDER CHANGES											
DATE	STEP	Р	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
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Part No	\•	PAR #-	Fault Ca	tegory:	NC	R. Ves N	lo DOA:	Date:					
Part No: PAR #:				QA: N/C Closed:									
NCR:			WORK OR	DER NON-CONFO	DRMANCI	E (NCR)	v	·					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Section B ption	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector					
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		Decemention of NC		Corrective Action Section B	Varidiantian			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto
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NOTE: Date & initial all entries

Date: Monday, 08/09/2008 2:51:00 PM User: Julie Lecocq **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: WEARPAD** Job Number: 41897 Part Number: D26483 Job Number: Seq. #: **Machine Or Operation:** Description: BRAKE NC NC BRAKE Comment: NC BRAKE 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. St 97/09/16 (4) 2-Identify as D2648-3 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 7.0 Comment: LARGE FABRICATION RESOURCE 1 Qty Description M107553 A/R560Hardcoat 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary VISUAL INSPECTION OF GROUND WELDS 8.0 QC10 Comment: VISUAL INSPECTION OF GROUND WELDS 9.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING 10.0 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE:** FINISH TIME: 11.0 QC3 INSPECT POWDER COAT/CHEMIC Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 12.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FP-14

Dart Aerospace Ltd

	•								
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
4.0									
			,						
						-			12
Part No:		PAR #:	Fault Categ	ory:	_ NCR: Ye	s No DQ	DQA: Date:		
Resolution:			Disposition	_ QA: N/C	Closed:		Date:		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	OTED	Description of NC		Corrective Action Section		Verifi	cation	Approvai	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	1& Sec	tion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Date:

Monday, 08/09/2008 2:51:00 PM

User:

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 41897

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21



FINAL INSPECTION/W/O RELEASE

08/09/24/

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





Dart Aerospace Ltd

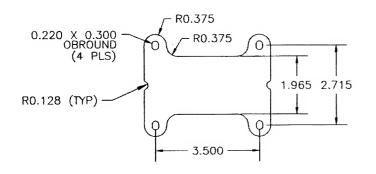
W/O:			W	ORK ORDER CHANG	SES					
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Part No:		PAR #:	Fault Cat	egory:	NCR: Ye	es No	No DQA: Date:			
Resolution:			Disposition: C			QA: N/C Closed:				
NCR:			WORK ORI	DER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC			tion B	- 0	Verification		Approval	Approval
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41897		
Description: Wearpad	Part Number:	D2648-3		
Inspection Dwg: D2648 Rev: D		Page 1 of 1		

193			FIRST A	ARTICLE IN	SPECTIO	N CHE	CKLIST	-				
			X	First Article	e	Prototy	ype					
	wing ension		Tolerance	Actual Dimension	Accept	Reject	Method Inspecti		Con	nments		
1.9	965		+/-0.010	1,910	*							
2.	715		+/-0.010	3,715	*							
3.	500		+/-0.010	3,498	*							
0.220	x 0.300	-	+/-0.010 x +/-0.010	201 X 307	*							
R0	.375		+/-0.010	375	*				2			
R0	.128		+/-0.010	. 128	*							
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Measu	Measured by:			Audited by:	_\$	Prototype Approval:			N/A			
	Date:		8-9-11	Date:	Date: 8/9/4				Date:			
Rev	Date		Change					Re	vised þy _A	Approved		
Α	06.10.1	6	New Issue					KJ.	JLM O			

D2648-1 FLAT PATTERN

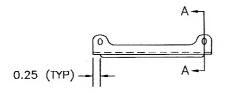


SECTION A-A R1.62 7560 HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.063 TO 0.125 THICK

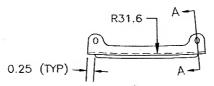
SECTION B-B R1.62 0.12 (TYP) 0.13

D2941-300 REMOVE POWDER COAT FROM THESE **SURFACES**

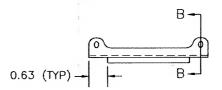
D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)







BREAK ALL SHARP CORNERS 0.063 MAX MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK) FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005 FOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED EDLERANCES ARE PER DART QSI
ALL DIMENSIONS ARE IN INCHES
ALL DIMENSIONS AR

AMENDMENT

99.11.17 ADDED 02648-7 С R31.6 WAS R19.6 97.06.26 В 97.05.30 ENLARGE OBROUND, 0.375 WAS 0.250 97.03.25 NEW ISSUE DESIGN DART AEROSPACE USA, INC DART RF CHECKED APPROVED DRAWING NO. D2648 SHEET 1 OF TILE SCALE 99.11.17 WEARPAD